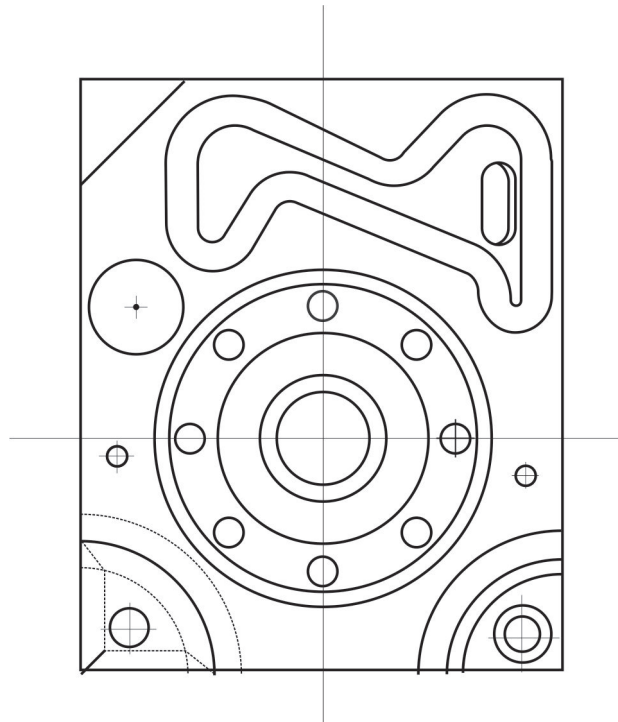


Further CNC feature measurement (non-CAD)



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1 Further CNC feature measurement (non-CAD)

1.1 Tutorial pre-requisites

- The student should have completed, and have a sound knowledge of all 'Alignment' tutorials

1.2 Tutorial objectives

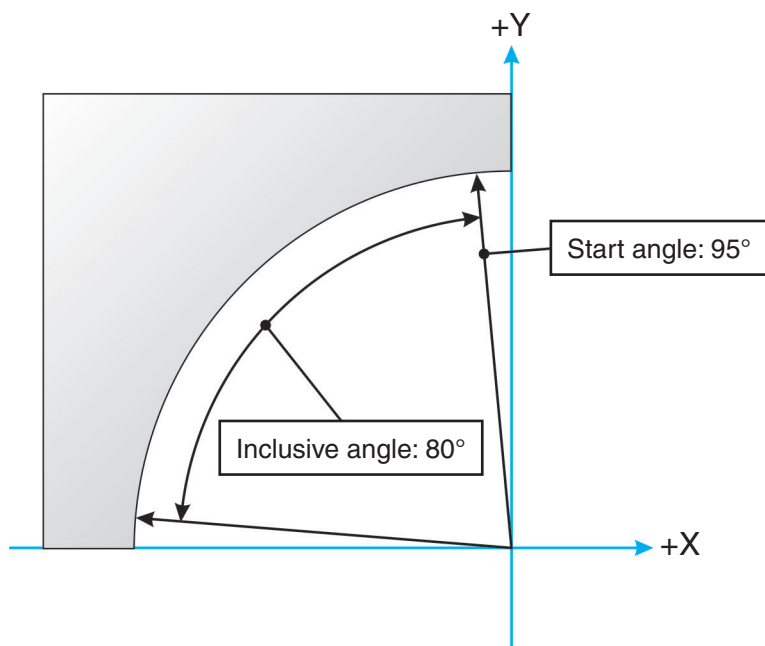
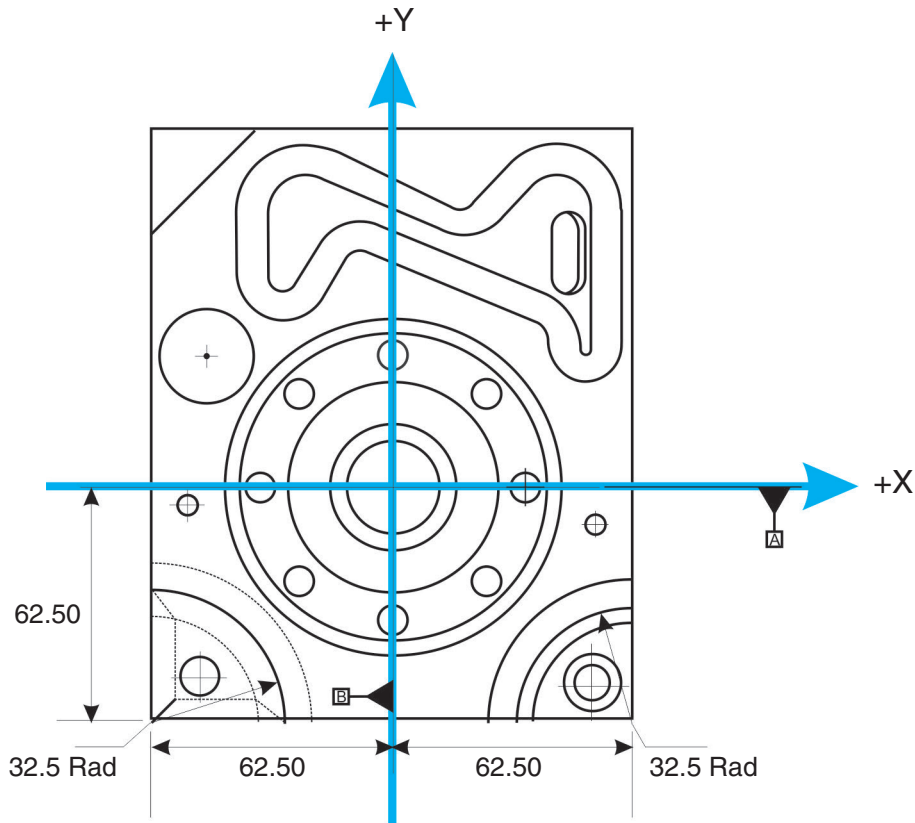
- Further exposure to feature measurement using data obtained from drawing definition
- Introduction to the use of 'multi' features
- Introduction to measurement in 'AUTO' mode and the settings that apply

2 Introduction

This tutorial will introduce the student to further CNC feature measurement options including multi-feature measurement. Additionally, the student will be introduced to a measurement settings and measurement options specific to running a program using automatically calculated movement and measurement paths.

3 Select a working plane

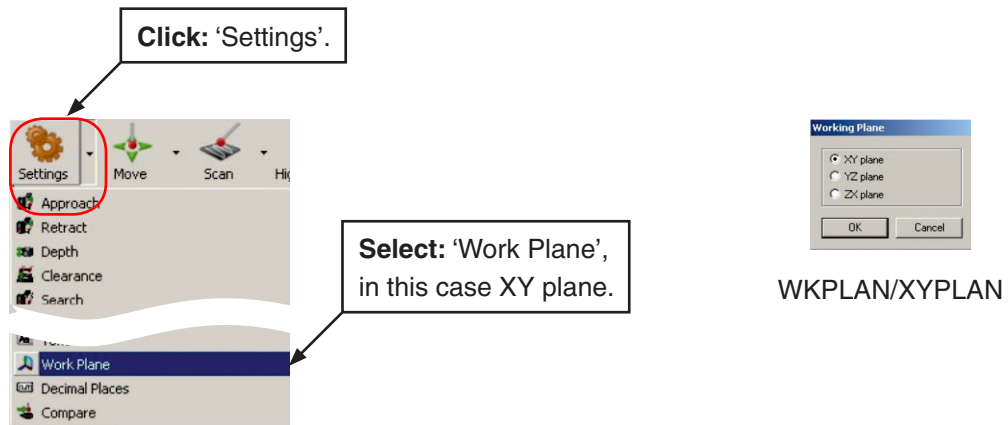
Prior to carrying out the following measurement the component must be precisely aligned.



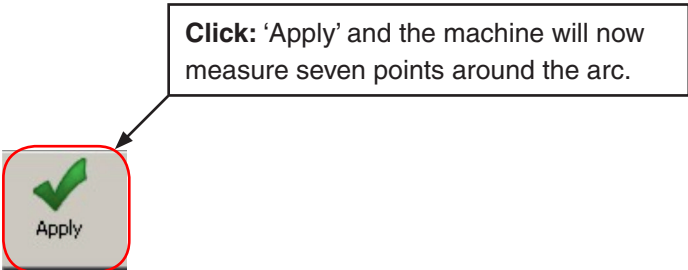
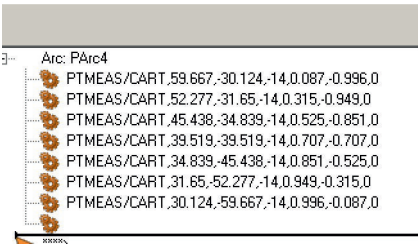
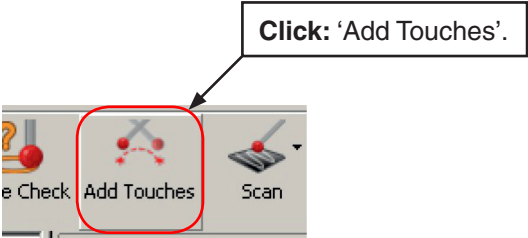
NOTE: 'Arc' measurement is the same as 'Circle' measurement with added parameter changes.

Move the probe to a clear position to inspect the radius.

Create a GOTO.



5 Measure an arc



Arc		ARC001				Inn		
		Actual	Nominal	Low tol	High to	Deviation	Status	Error
X axis		62.499	62.5			-0.001		
Y axis		-62.499	-62.5			0.001		
Z axis		-14	-14			-0		
I		0	0					
J		0	0					
K		1	1					
Zero refer		1	1					
Zero refer		0	0					
Zero refer		0	0					
Start angl		95	95					
Included angl		80	80					
Radial		32.499	32.5			-0.001		

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